

Aero Design Ltd.**Work Order Control Sheet**Work Order#: 2017-169 Date Opened: 16 October 2017 Title: AssemblyAircraft OEM: Eurocopter Aircraft Model: AS350 Product Type: Cargo Basket Product Model: XL Ski Quantity: 1**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification
Time Sheet (R&D)
Notes

Initial or N/A

JC
N/A
JC
JC
N/A
JC
N/A
N/A

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

1
N/A
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

CB/JC
CB/JC

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
N/A
N/A
N/A

Drawing List

Drawing #	Rev #	Description	Initial or N/A
94010	1	Basket Assembly	JC
70405	4	Lid Walkway Mod.	JC
84240	0	Lid Brace Installation	JC
84255	2	Handle Installation	JC
94027	1	Placard	JC
84261	2	Handle Assembly	JC

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A

Traveller

Install walkway on lid
Install lid on basket body
Re-tap mounting lug holes and install mount lugs
Install handle brackets
Install handle
Install lid prop
Install data plate

Initial or N/A

CB/JR
CB/JR
CB/JR
CB/JR
CB/JR
CB/JR
CB/JR

Work performed by:

Print: C. Brander/J. Rekve

Sign: 

SCA: AD01

Date: 26-Oct-17

ICC / Dual Inspection performed by:

Print: J. Clarke

Sign: 

SCA: AD02

Date: 26-Oct-17

Work Order closed by:

Print: J. Clarke

Sign: 

SCA: AD02

Date: 10-Nov-17

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

Tread Plate

Aircraft:

All

Model: N/A

Description:

Lid Walkway Checker Plate

Supplier:

Ryerson

Color:

Aluminum

WO#:

N/A

PO# 17081



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

MS20001P4-9600

Aircraft:

All

Model: All

Description:

Hinge

Supplier:

GKN Aerospace Bandy Machining

Color:

N/A

WO#:

N/A

PO# 17017



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 Ski Body No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 94011-01 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-133-03

Remaining Tasks to be Performed: See reverse.

Signature: *Pavel Marty*

Date: Sept. 19/2017 Lic. No. / SCA 7304

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Steps: 10.

11.

12.



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

In Process

Remarks

Steps: 11.

12.

13.



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: AS350 XL Lid No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 94012-01 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-133-04

Remaining Tasks to be Performed: See reverse.

Signature: [Signature]

Date: Sept. 19 / 2017 Lic. No. / SCA 73-04

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: XL Basket Handle No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 84261 Rev 3 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-118

Remaining Tasks to be Performed: Install

Signature: David Marty

Date: July 19/2017 Lic. No. / SCA AD-05

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2017-0400	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2017-169	
6. Item 1.	7. Description Cargo Basket	8. Part Number 94010-01	9. Qty. 1	10. Serial/Batch No. 94001-82	11. Status/Work New	
12. Remarks Modified with walkway on lid IAW DCL704; Black						
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.			
13b. Signature  AD 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 26 Oct 2017		14d. Name		14e. Date (dd/mmm/yyyy)
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

ARROW HELICOPTERS

2017-169

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	UPDATE TITLE BLOCK; UPDATE ADDRESS AND LOGO; MAT'L THICKNESS CHANGED	BJC	10/07/2014

NOTES

1. ENGRAVE 0.007 DEEP AS FOLLOWS:
 "QUICK RELEASE BASKET" - 0.125 HIGH
 "EUROCOPTER AS350 & AS355 SERIES" - 0.080 HIGH
 "S/N 94001-XX" - 0.080 HIGH
 "MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH
 "300 LBS/136 KG" - 0.200 HIGH
 "AERO DESIGN LTD." - 0.125 HIGH
 "POWELL RIVER, BC, CANADA" - 0.080 HIGH
 "www.aerodesign.ca" - 0.080 HIGH


DRILL #30 (0.129)
4 PLACES



01 PLACARD

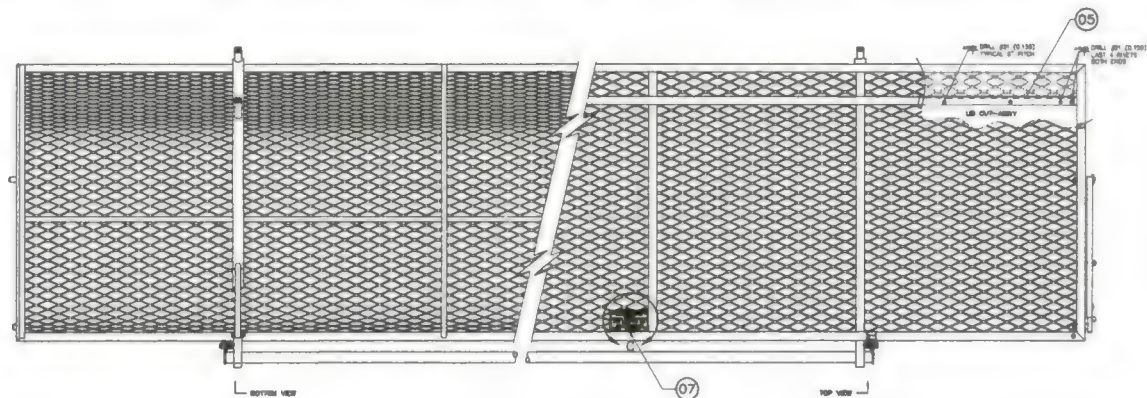
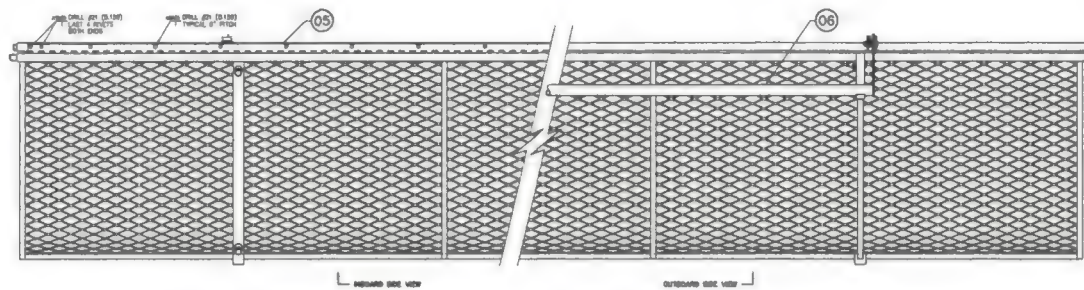
94027-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

LIST OF MATERIALS

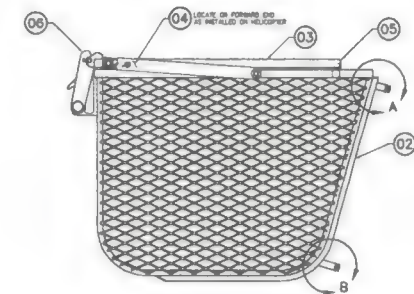
THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.	APPROVALS	DATE	 AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 804.483.2378 www.aerodesign.ca	
	DRAWN: R. RATHWELL	OCT 3, 2011		
	CHECKED: E. BURGAIN			
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1		EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET PLACARD	
	SCALE 1 : 1 SHEET 1 OF 1		DWG. SIZE A4	DWG. NO. 94027

2017-169

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	UPDATE WIRE BLOCK ADD A "PRIVATE" TYPE TO HARDWARE PARTS UPDATED	BUC	12/21/2014
	CHANGE BRACE ASSEMBLY TO INSTALLATION		



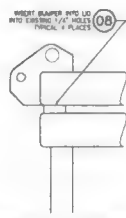
④ 10-01 CARGO BASKET ASSEMBLY - RH



DETAIL A
SCALE 1/2"
TYPICAL FRONT AND REAR



DETAIL B
SCALE 1/2"
TYPICAL FRONT AND REAR



BUMPER INSTALLATION



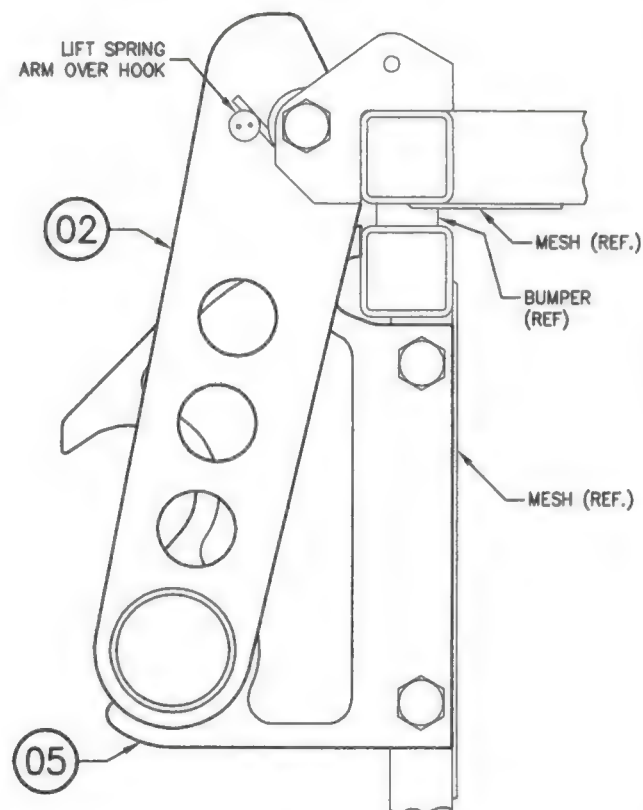
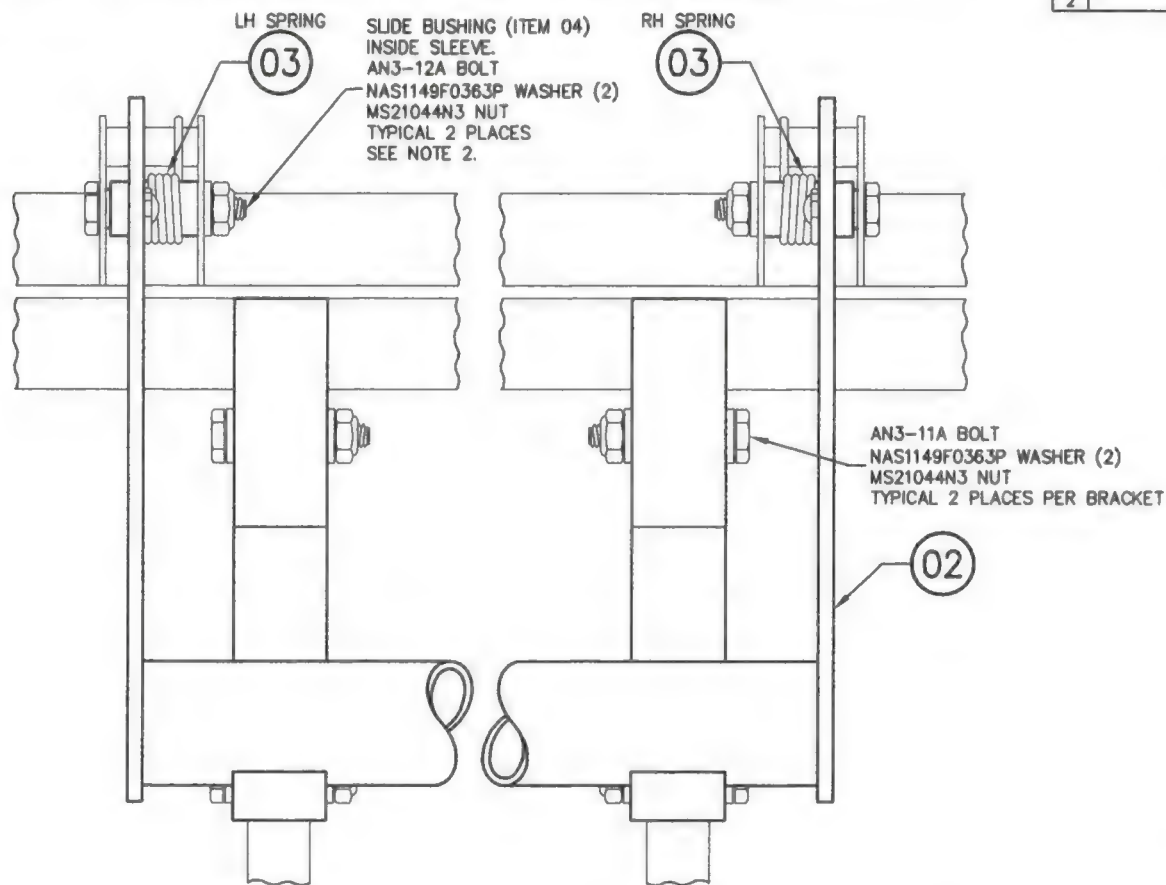
DETAIL C
SCALE 1"
LOOKING AT PLACARD BRACKET

[illegible][illegible]

2017-169

NOTES:

1. THIS DRAWING IS AN ALTERNATE CONFIGURATION FOR THE HANDLE INSTALLATION SHOWN ON DRAWING 36255.
2. GREASE BUSHING (ITEM 04) USING MOBILGREASE 28 OR EQUIVALENT PRIOR TO INSTALLATION.



(01) HANDLE INSTALLATION

A/R	MOBILGREASE 28		GREASE	MIL-PRF-81322F
4	AN3-11A		BOLT	
2	AN3-12A		BOLT	
10	NAS1149F0363P		WASHER	
6	MS21044N3		NUT	
2	84267-01	05	BRACKET	
2	36275-01	04	BUSHING	
2	36278-01	03	SPRING (1 LH, 1 RH)	
1	84261-01	02	HANDLE BAR ASSEMBLY	
	84255-01	01	HANDLE INSTALLATION	
01	PART NO.	ITEM	DESCRIPTION	MATERIAL
QTY.	LIST OF MATERIALS			

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 36255	BJC	NOV 03/09
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; ADD NOTE 2; HARDWARE UPDATED	BJC	MAR 13/14

APPROVALS	DATE
DRAWN: JEFF CLARKE	03 NOV 2009
CHECKED: E. BURGON	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ± 0.010 $\pm 1/2^\circ$
X.XX ± 0.03
X.X ± 0.1



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POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 854.483.8374 www.aerodesign.ca

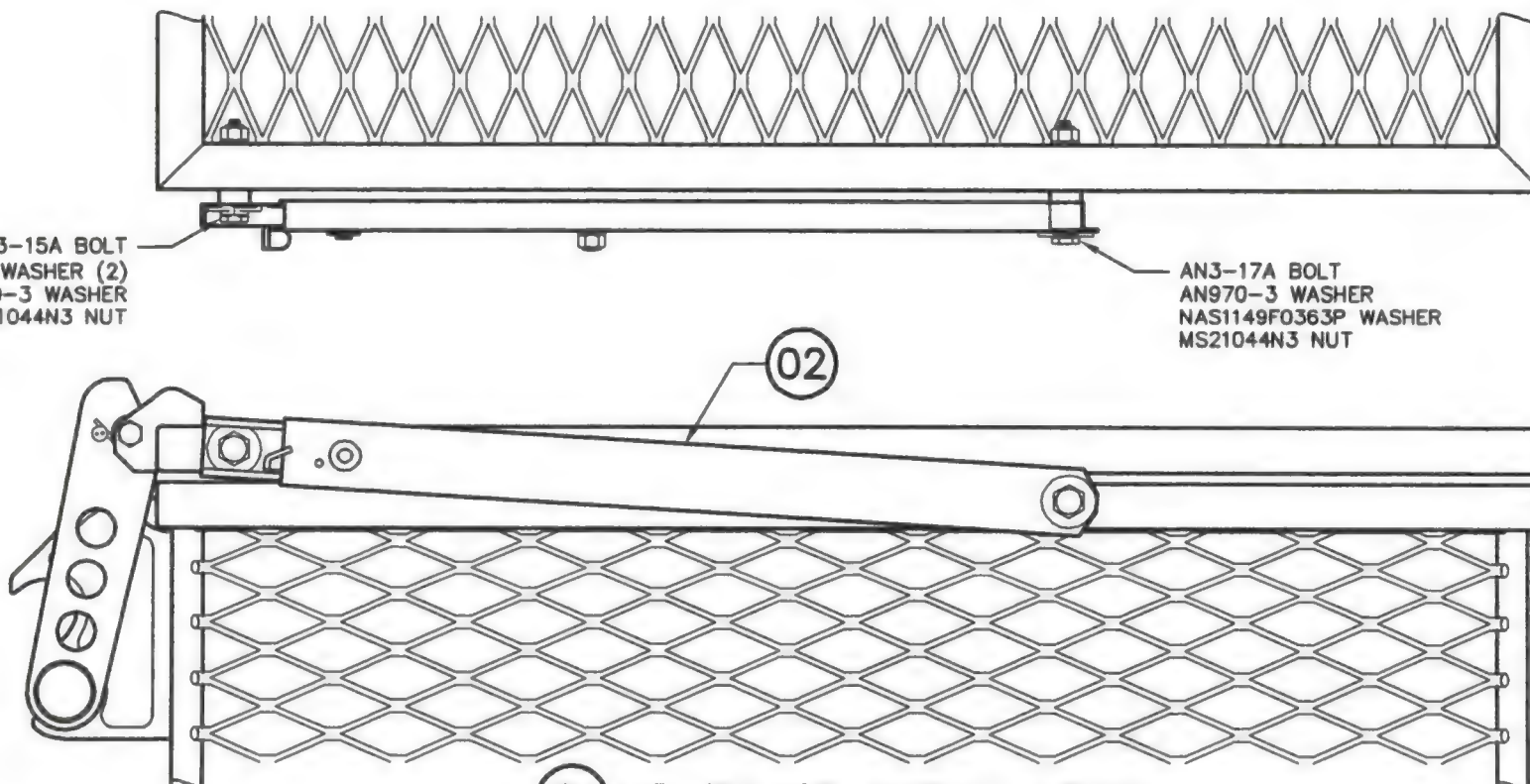
HELICOPTER CARGO BASKET
HANDLE BAR INSTALLATION

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84255	2

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AN3-15A BOLT
NAS1149F0363P WASHER (2)
AN970-3 WASHER
MS21044N3 NUT

- AN3-17A BOLT
AN970-3 WASHER
NAS1149F0363P WASHER
MS21044N3 NUT



NOTES

1. THIS DRAWING APPLIES TO ALL AERO DESIGN LTD. CARGO BASKET ASSEMBLIES.
LID PROP IS TO BE INSTALLED ON THE FORWARD END OF THE BASKET AS INSTALLED ON THE HELICOPTER.

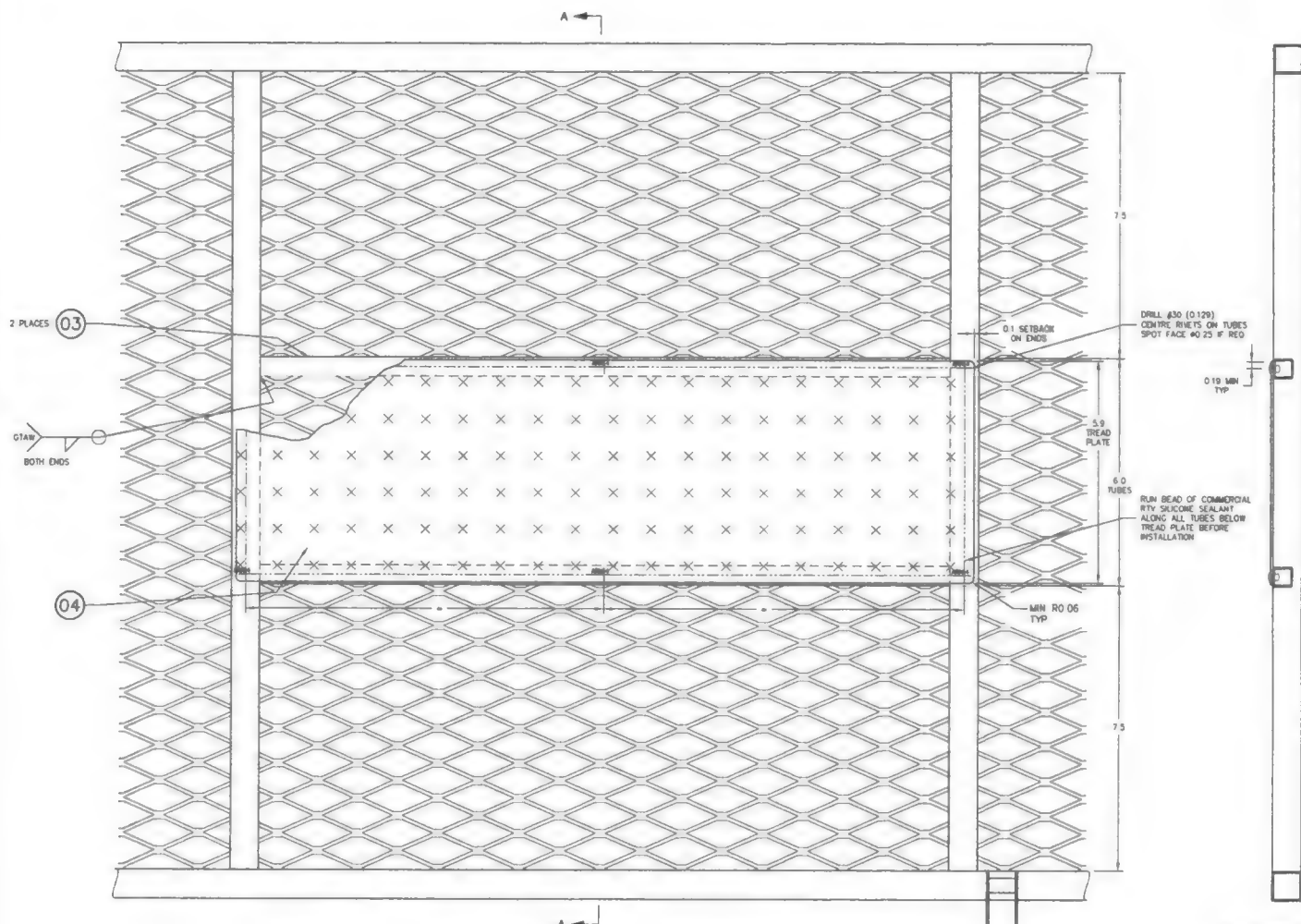
APPROVALS	DATE
DRAWN: JEFF CLARKE	21 MAY 2014
CHECKED: JASON REKVE	21 MAY 2014

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:

DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

	<h1 style="text-align: center;">AERO DESIGN LTD.</h1>		
	<p style="text-align: center;">9088A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.683.2576 www.aerodesign.ca</p>		
<h2>HELICOPTER CARGO BASKET</h2> <h3>ALL MODELS</h3> <h3>LID BRACE INSTALLATION</h3>			
NOT TO SCALE	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A4	84240	0

2017-169



01 BASKET LID ASSEMBLY

SECTION A-A

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL MEDIUM AND EUROCOPTER AS330 BASKETS, CHANGE TUBES	BUC	MAR 19/08
2	ADD EUROCOPTER EC135 MCDONNELL DOUGLAS MD600N BELL 208B BASKETS	BUC	DEC 4/08
3	ADD NEW AS330 AND 208L/407 MODELS	BUC	DEC 4/08
4	TITLE BLOCK UPDATED, MODEL LIST REMOVED, ADD ALT RIVET, ADD NOTE 7	BUC	29/05/2014

NOTES

- THIS DRAWING IS AN OPTIONAL CONFIGURATION ADDING A TREAD PLATE STEP TO THE LID. THIS CONFIGURATION MAY BE APPLIED TO ANY OR ALL BAYS OF THE LID. REMAINDER OF LID ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS.
- TUBES (ITEM 03) MUST BE WELDED IN PLACE BEFORE MESH IS WELDED ON BOTTOM.
- REMOVE ALL BURRS AND BREAK SHARP EDGES.
- WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2885C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
- WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
- THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY. INSTALL TREAD PLATE AFTER POWDER COATING.
- WIDTH AND POSITION OF LID STEP MAY BE ADJUSTED TO MATCH LID DOOR INSTALLED IN ACCORDANCE WITH DRAWING 70402 ON ADJOINING BAY OF THE LID.

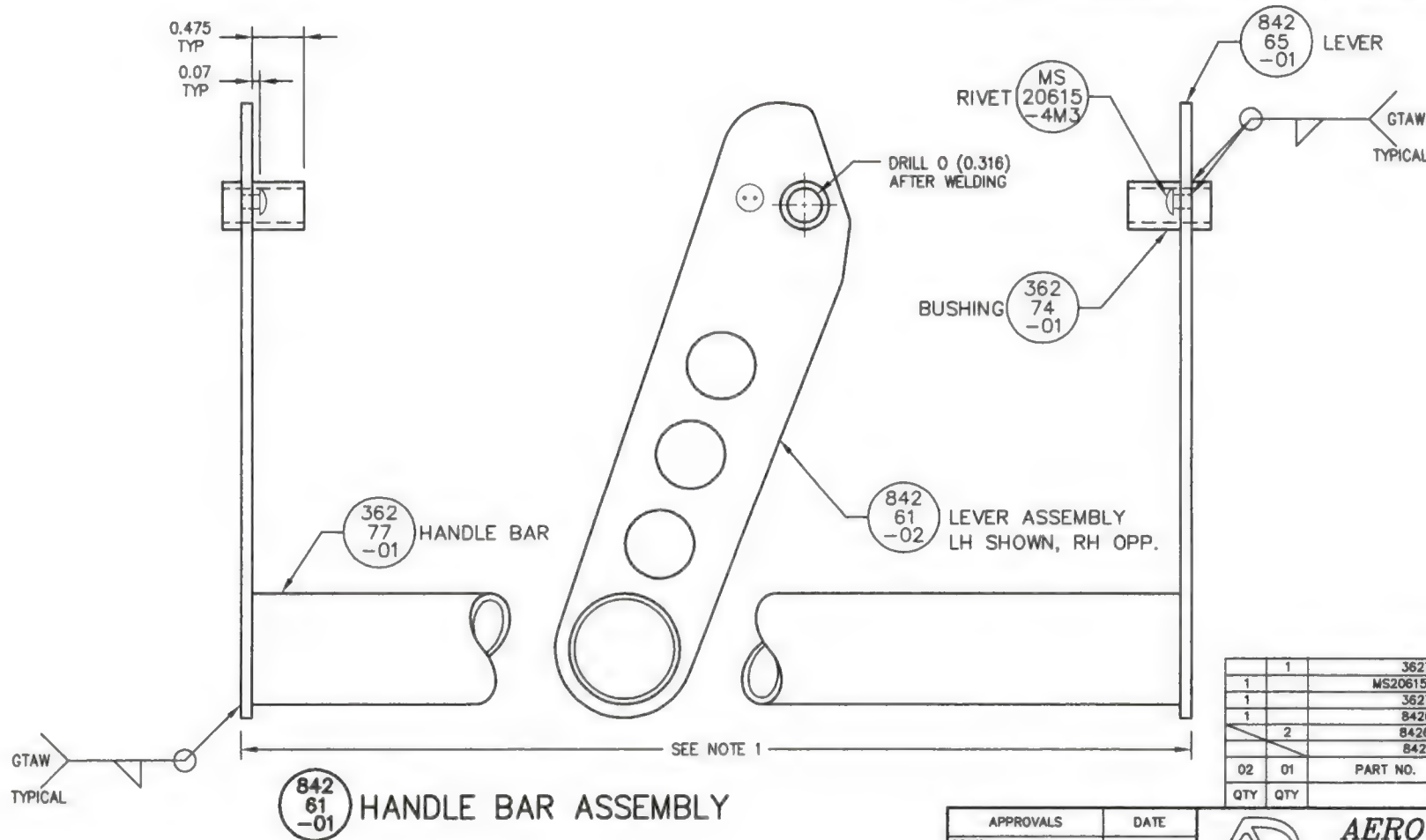
A/R	CR3213-4-02	BLIND RIVET	ALTERNATE HR3213-4-02			
1	70405-04	D4 TREAD PLATE	ALUMINUM	COMMERCIAL	0.083 TREAD PLATE	
2	70405-03	D3 TUBE	4130 STEEL COND N	MIL-T-6736	0.5 x 0.035 WALL TUBE	
1	SEE NOTE 1	D2 BASKET LID ASSEMBLY				
1	70405-01	D1 BASKET LID ASSEMBLY - MODIFIED WITH STEP				
D1	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY				LIST OF MATERIALS		

LIST OF MATERIALS

BASIC CODE REF HAS 523		DASH NO FOR DIAMETER N=NO HEAD NEAR SIDE F=NO HEAD FAR SIDE		DASH NO FOR LENGTH		APPROVALS DRAWN: JEFF CLARKE CHECKED: E. BURGON		DATE 21 SEPT 2008	
C=COUNTERSUNK D=DIMPLE DIGIT=# OF SHEETS TO BE DIMPLED		BASIC CODES: BJ=MS20470AD BB=MS20426AD ARN=CR3213 ARM=CR3212		<input type="checkbox"/> INSTALL NEW RIVET <input type="checkbox"/> REMOVE/REPLACE RIVET <input type="checkbox"/> EXISTING RIVET		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1		SCALE 1:15 SHEET 1 OF 1	
AERO DESIGN LTD. 8888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 804 485.8779 www.aerodesign.ca						CARGO BASKET LID STEP MODIFICATION			
A1		70405		4					

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; LEVER ASSEMBLY ASSIGNED P/N	BJC	MAR 13/14



NOTES:

1. LENGTH OF HANDLE TO BE DETERMINED BY BASKET ASSEMBLY DRAWING.
2. REMOVE ALL BURRS AND SHARP EDGES.
3. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ER308L ROD.

QTY	QTY	PART NO.	DESCRIPTION
1		36277-01	HANDLE BAR
1		MS20615-4M3	RIVET (MONEL)
1		36274-01	BUSHING
1		84265-01	LEVER
2		84261-02	LEVER ASSEMBLY (RH/LH)
		84261-01	HANDLE BAR ASSY
02	01		

APPROVALS	DATE
DRAWN: R. RATHWELL	JUNE 18/09
CHECKED: E. BURGOIN	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ±0.010 ±1/2°
X.XX ±0.03
X.X ±0.1



AERO DESIGN LTD.

9888A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 804.483.8376 www.aerodesign.ca

**HELICOPTER CARGO BASKET
HANDLE BAR ASSEMBLY**

SCALE	SIZE	DWG. NO.	REV.
SCALE 1 : 1	A3	84261	2
SHEET 1 OF 1			

Work Order: 2017-169

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Basket Assembly

1 of 2

Date Opened: 16 Oct 2017

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>		94010-01	Cargo Basket Assembly		<u>S/N 94001-82</u>
Step 1				<i>Lid Assembly</i>		
	<u>1</u>		94012-01	Basket Lid Assembly		<u>2017-133-04</u>
Step 1.a.	<u>4</u>		49205-14	Bumper	Argus Industries Bumper	<u>See PDS</u>
	<u>A/R</u>		--	Sealant	Commercial Silicone RTV sealant	<u>See CMB</u>
Step 1.b.	<u>1</u>		94027-01	Placard	0.063 Sheet, 6061-T6 Aluminum	<u>94001-82</u>
	<u>4</u>		CR3213-4-02	Cherry Rivet		<u>See CMB 17070</u>
Step 1.c.	<u>1</u>		70405-01	Lid Step Modification		
(option)	<u>1</u>		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	<u>17081</u>
	<u>A/R</u>		CR3213-4-02	Cherry Rivet		<u>17070</u>
	<u>A/R</u>		--	Sealant	Commercial Silicone RTV sealant	
Step 2				<i>Basket Assembly</i>		
Step 2.a.	<u>1</u>		94011-01	Basket Body Assembly		<u>2017-133-03</u>
	<u>4</u>		96710-01	Fitting	Alternate: Ancra 40088-14	<u>See PDS</u>
	<u>8</u>		AN960-616	Washer		<u>See PDS</u>
Step 3				<i>Hinge Installation</i>		
	<u>1</u>		MS20001P4	Piano Hinge	95"	<u>17017</u>
	<u>8</u>		CR3523-5-02	Cherry Rivet		<u>See CMB 16063</u>
	<u>A/R</u>		CR3213-5-02	Cherry Rivet		<u>17070</u>
Step 4	<u>1</u>		84255-01	<i>Handle Installation</i>		
Step 4.a.	<u>2</u>		84267-01	Bracket	Delrin, 3/4" Sheet	<u>2017-30</u>
	<u>4</u>		AN3-11A	Bolt		<u>See PDS</u>
	<u>8</u>		NAS1149F0363P	Washer		<u>See PDS</u>
	<u>4</u>		MS21044N3	Nut		<u>See PDS</u>

Work Order: 2017-169Date Opened: 16 OCT 2017Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Basket Assembly

2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	.. 1		84261-01	Handle Assembly		2017-118
	.. 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	See PDS
	.. 2		36275-01	Bushing	Brass, 5/16" Dia	See PDS
	.. 2		AN3-12A	Bolt		See PDS
	.. 4		NAS1149F0363P	Washer		See PDS
	.. 2		MS21044N3	Nut		See PDS
Step 5				Lid Brace Installation		
	. 1		36280-01	Brace Assembly		2017-170
	. 1		AN3-15A	Bolt		See PDS
	. 1		AN3-17A	Bolt		See PDS
	. 2		AN970-3	Washer		See PDS
	. 3		NAS1149F0363P	Washer		See PDS
	. 2		MS21044N3	Nut		See PDS
Step 6				Inspection	None	



WO# 2017-169

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013

JO BASKET ASSEMBLY - COMMON

Work Order: 2017-169

Date Open: 16 OCT 2017

General

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details. Drawings are linked to the source for ease of printing.

		Basket			Lid	Lid	Handle		
✓	Basket Type	Ass'y	Placard	Mat'l	Walk	Prop	Inst'n	Ass'y	Mat'l
Bell 206B – right side only									
	Short	80210	80227	Mat'l	70405	84240	84255	84261	Mat'l
	Medium	80310	80327	Mat'l					Mat'l
	Long	81110	81127	Mat'l					Mat'l
Bell 206L/407 – Right side only									
	Low Standard	69810	69827	Mat'l	70405	84240	84255	84261	Mat'l
	Low Wide	94510	94527	Mat'l					Mat'l
	Low Ski	94610	94627	Mat'l					Mat'l
	High Ski	76610	76625	Mat'l					Mat'l
Bell Medium – left or right									
	Standard	75110	75127	Mat'l	70405	84240	84255	84261	Mat'l
	Extra Large (ski)	95510	95527	Mat'l					Mat'l
	Mega	100610	100627	Mat'l					Mat'l
Bell 429 – right or left									
	Standard – Pre S/N 71	95910	95927	Mat'l	70405	84240	84255	84261	Mat'l
	Standard – Post S/N 71	95950	95927	Mat'l					Mat'l
Eurocopter AS350/AS355 – left or right									
	Short	77610	77627	Mat'l	70405	84240	84255	84261	Mat'l
	Medium	76410	76427	Mat'l					Mat'l
	Long	78410	78427	Mat'l					Mat'l
	Ski	94010	94027	Mat'l					Mat'l
Robinson R44 – left or right									
	Standard	90610	90627	Mat'l	70405	84240	84255	84261	Mat'l
MD600									
	Standard	82810	82827	Mat'l	70405	84240	84255	84261	Mat'l

Hyperlinking to specific excel sheet –

1. on desired excel sheet cell A1, set name of cell, eg. Assembly.
2. at end of hyperlink add #Assembly (filename.xls#Assembly).

CMBOK

1. Lid Assembly

a. Install lid bumpers on bottom.

- i. Drill $\frac{1}{4}$ " holes using center drill, 3 (standard/medium) or 4 (long/ski) places.
- ii. Fill bumper holes with RTV silicone sealant.
- iii. Insert 49205-14 lid bumper, 3 or 4 places per lid.

b. Install placard on bracket on top of lid

Note: 959 and 1006 placard is installed on body.

- i. Locate placard on bracket.
- ii. Drill #30 through placard and bracket, using holes in placard.
- iii. Remove placard and de-burr holes in placard and on bracket.
- iv. Locate placard on bracket, and cleco in place.
- v. Rivet placard with four CR3213-4-02 CherryMax rivets.

c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)

- i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
- ii. Pull tread plate from stock. Shear tread plate to length.
- iii. De-burr edges of tread plate with scotch-brite wheel on bench grinder.
- iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
- v. Mark and drill #30 holes:
 1. 0.25" from edge of tread plate, centre on cross members (0.38")
 2. 0.25" from edge of tread plate, middle of each walkway stringer
- vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using $\frac{1}{4}$ " piloted counter bore on both sides.
- vii. De-burr holes in lid tubes.
- viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
- ix. Set tread plate in place, secure with clecos if necessary.
- x. Rivet placard with CR3213-4-02 CherryMax rivets

d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

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2. Body Assembly

a. Install attachment fittings

- i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
- ii. Run 3/8-24 tap into attachment lugs to clear threads.
- iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
- iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
 1. 90610 (Robinson R44) basket only:
 - a. Install 1 fitting 90628-01 in lower forward attachment lug only.
 - b. Install 3 96710-01 fittings in remaining locations.
- v. Torque to 160-190 in-lbs (13.3-15.8 ft-lbs).

- b. 959 and 1006 Baskets only: Install inboard sheet on upper rim of basket
 - i. Locate sheet on basket.
 - ii. Drill #30 through sheet and rim, located as specified on drawing. Cleco in place.
 - iii. Remove sheet and de-burr holes in sheet and rim.
 - iv. Apply bead of RTV silicone sealant along all tubes under sheet.
 - v. Locate sheet on basket, and cleco in place.
 - vi. Rivet sheet with CR3213-4-02 CherryMax rivets.
- c. 959 Basket only: Install forward sheet
 - i. Locate sheet on basket. Ensure sufficient clamps are in place.
 - ii. Drill #30 through sheet, rim and hoop, located as specified on drawing. Cleco in place.
 - iii. Remove sheet and de-burr holes in sheet and rim.
 - iv. Apply bead of Pro-Seal sealant along all tubes under sheet.
 - v. Locate sheet on basket, and cleco in place.
 - vi. Rivet sheet with CR3213-4-02 CherryMax rivets.
- d. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

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3. Hinge Installation

- a. Prepare hinge.
 - i. Cut hinge to length:
 - 1. 776, 906 – 54"
 - 2. 751, 803 – 70"
 - 3. 698, 764, 945 – 72"
 - 4. 766, 784 – 90"
 - 5. 940, 946, 959 – 95"
 - 6. 1006 – 107"
 - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
 - i. Locate hinge on basket (standard baskets)
 - 1. centre fore/aft
 - 2. 0.15" – 0.18" up from bottom edge
 - ii. Locate hinge on basket (extra wide baskets)
 - 1. centre fore/aft
 - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
 - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
 - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
 - v. Remove hinge and de-burr holes in hinge and basket rim.
 - vi. Cleco hinge to basket with 5/32 clecos.
 - vii. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations

- c. Install lid on basket
 - i. Locate lid on hinge (all baskets)
 - 1. center fore/aft
 - 2. 0.15" – 0.18" down from top edge
 - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
 - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
 - iv. Remove hinge and de-burr holes in hinge and lid rim.
 - v. Cleco lid to hinge with 5/32 clecos.
 - vi. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations
- d. Record PO of hinge and rivets on attached material tracking list.

4. Install Handle

- a. Install handle brackets.
 - i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
 - ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
 - iii. Torque AN3 bolts to 20-25 in-lbs.
- b. Install handle
 - i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
 - ii. Grease two 36275-01 bushings with Mobil Grease 28 or equivalent. Insert into bushings of handle assembly.
 - iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
 - iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
 - v. At first end, remove bolt and repeat step iv.
 - vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
 - vii. Torque AN3 bolts to 20-25 in-lbs.
- c. Check handle
 - i. Operate handle to ensure handle does not bind and springs hold handle in.
 - ii. Snap handle into brackets to ensure handle locks.
- d. Record PO/WO of all parts used in steps above on attached material tracking list.

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5. Install lid brace

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to 20-25 in-lbs.
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

6. 946 Basket Only: Install Cutout Brace

- a. Locate 94621-01 Brace over aft cross tube cutout.
- b. Install two AN4-6A bolts and two AN4-27A bolts with NAS1149F0463P washers.
- c. Torque AN4 bolts to 50-70 in-lbs.

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7. Final Inspection

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
 - i. Bolts are tight
 - ii. Rivets are installed correctly
 - iii. Handle operates correctly
 - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.